

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009326**Date Inspected:** 22-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Ma Yun, Li Ming**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower/OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Utekar Shrikant was present during the times noted above for observations relative to the work being performed.

BAY # 10

This QA Inspector randomly observed the following work in progress.

SMAW welding process of weld joint 1B located on PCMK ED1-A5007-24. Welder is identified as 057258 ZPMC QC is identified as Ma Yun. The welding variables recorded by QC appeared to comply with the WPS-485-SMAW-1G (1F) Repair. The weld repair report observed as T-WR2224 and ZPMC Ultrasonic Inspection report noted as T787-UT-2255.

FCAW welding process of weld joint 1A located on PCMK NSD1-SPSA3-56. Welder is identified as 040533ZPMC QC is identified as Ma Yun. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-TC-U5-F.

BAY # 11

This QA Inspector randomly observed the following work in progress.

FCAW welding process of weld joint 78 located on PCMK WSTL3-4B/K. Welder is identified as 042218ZPMC

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QC is identified as Guo Peng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-TC-U4-F.

FCAW welding process of weld joint 79 located on PCMK WSTL3-4K/K. Welder is identified as 046706 ZPMC QC is identified as Guo Peng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U2A-F.

FCAW welding process of weld joint 77 located on PCMK WSTL3-4K/K. Welder is identified as 049220 ZPMC QC is identified as Guo Peng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-B-U2A-F.

FCAW welding process of weld joint 66 located on PCMK ESTL4-2C/L. Welder is identified as 040655 ZPMC QC is identified as Mao Bin Bin. The welding variables recorded by QC appeared to comply with the WPS-B-T-4314-TC-P4-1.

TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT 1AAE- 1AE

FCAW welding process of weld joint 38 located on PCMK OBE1. Welder is identified as 067103 ZPMC QC is identified as Zhang Hai Tao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133.

OBG SEGMENT 3AW- 3BW

This QA Inspector observed ZPMC personnel performing spray painting in OBG segment 3AW and 3BW from PP19 to PP 23.

OBG SEGMENT 4AW- 4BW

This QA Inspector observed ZPMC personnel performing sand blasting in OBG segment 4AW and 4BW on bottom panel.

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 13482570045, who represents the Office of Structural Materials for your project.

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Inspected By: Utekar,Shrikant

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer